

Work Order ID ~~66742~~

Friday, February 25, 2011 12:10:12 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: 11-02-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 115728

0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

Handwritten: 11.03.28
Handwritten: 11.03.28

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Handwritten: 11.03.28
Handwritten: 11.03.28

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Page 2

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	2/25/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/11/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat***								
	Start Time:								
	Oven Temperature:								
	Finish Time:								

140	Wing Walk as per dwg QSI005 4.4 Batch								
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								
	2- Install placard and label as per dwg								
	***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***								

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Item ID: D3914-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Lid Assembly (350)

Start Date: 2/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30

MF
11-03-23

Picklist Print

Friday, February 25, 2011 12:10:18 PM

Page 1

Work Order ID: 66742

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	22.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>64112</div> <div>65950</div> </div> <div> <div>Loc Qty</div> <div>22</div> <div>1</div> <div>21</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3914-1 Rib		Manufactured	No			100	Each	0.0000	2	2			
D3914-7 Rib		Manufactured	No			100	Each	0.0000	2	2			
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	15.0000	3	3			
<div> <div>Location</div> <div>WA</div> <div>65951</div> <div>66286</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>12</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D4018-5 Rib		Manufactured	No			100	Each	34.0000	9	9			
<div> <div>Location</div> <div>WA</div> <div>65428</div> <div>66289</div> </div> <div> <div>Loc Qty</div> <div>34</div> <div>4</div> <div>30</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													



B66500 (2x) 11.03.21



B66619 (2x) 11.03.21



B66620 (2x) 11.03.21



B65951 (3x) 11.03.21



9x 11.03.21

(9x)

Picklist Print

Friday, February 25, 2011 12:10:18 PM

Page 2

Work Order ID: 66742

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-5

Manufactured No

100 Each

2.0000

1 1



Mesh (350 Basket Long, Lid)



B66518 (K) 11.03.23

Location

Loc Qty

Loc Code

WA

2

60643

1

65459

1

D4021-3

Manufactured No

100 Each

6.0000

1 1



Data Plate



11.03.21

Location

Loc Qty

Loc Code

WA

6

56050

1

65916

1

65922

4

D4035-041

Manufactured No

100 Each

2.0000

1 1



Lid Rib Assembly, Fwd (350 Basket)



B67374 (W) 11.03.21

Location

Loc Qty

Loc Code

WA

2

66498

2

D4035-043

Manufactured No

100 Each

4.0000

1 1



Lid Rib Assembly, Aft (350 Basket)



11.03.21

Location

Loc Qty

Loc Code

WA

4

66288

1

66499

1

66544

2

(1x)

Friday, February 25, 2011 12:10:19 PM

Shop Packet Print

Page 2

Picklist Print

Friday, February 25, 2011 12:10:19 PM

Page 3

Work Order ID: 66742



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured

No

140

Each

0.0000

1

1



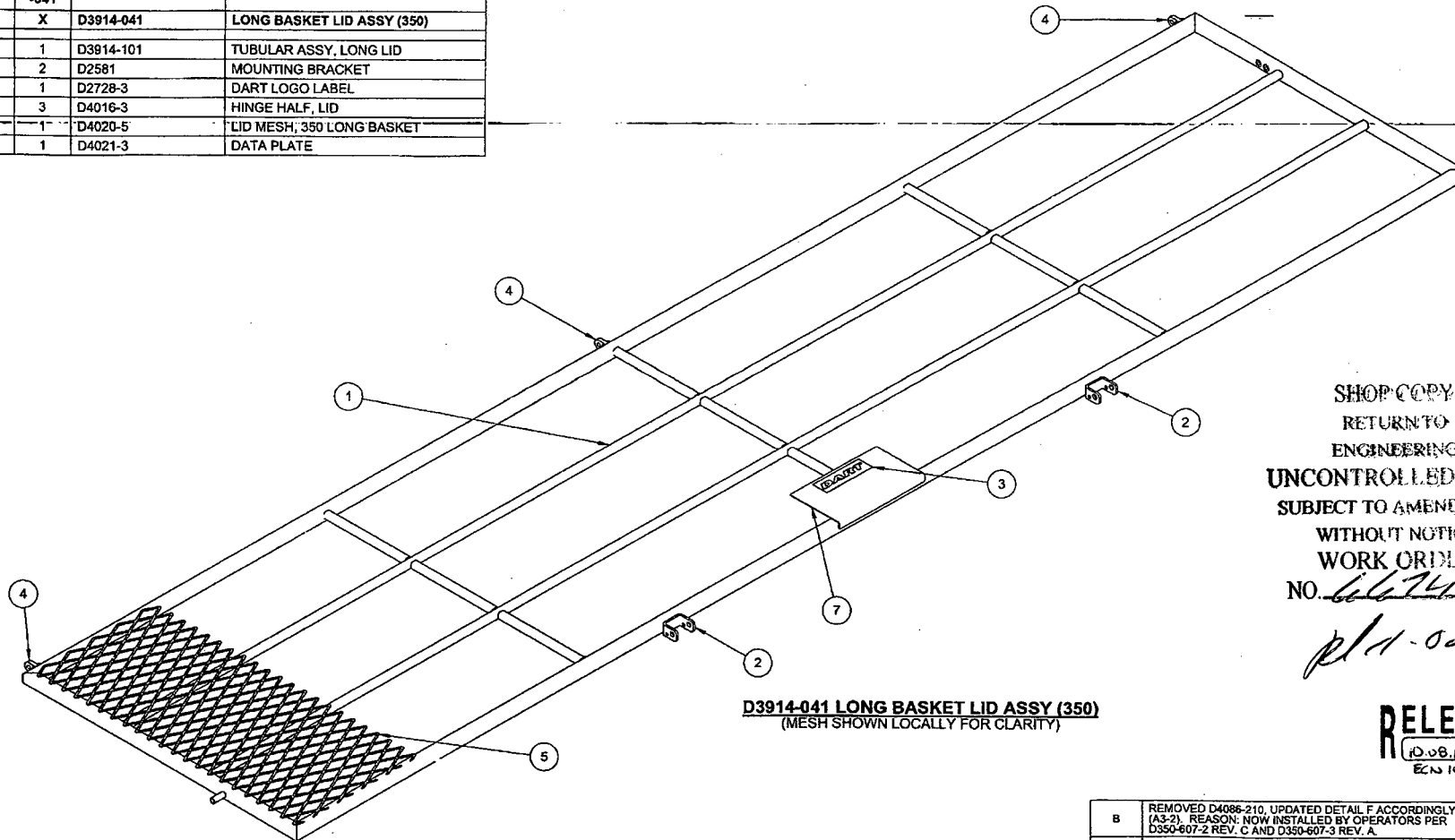
Dart Logo label

M115050



(x1) 98 1103/29

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66742

PL-1-02-25

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) REV. B SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

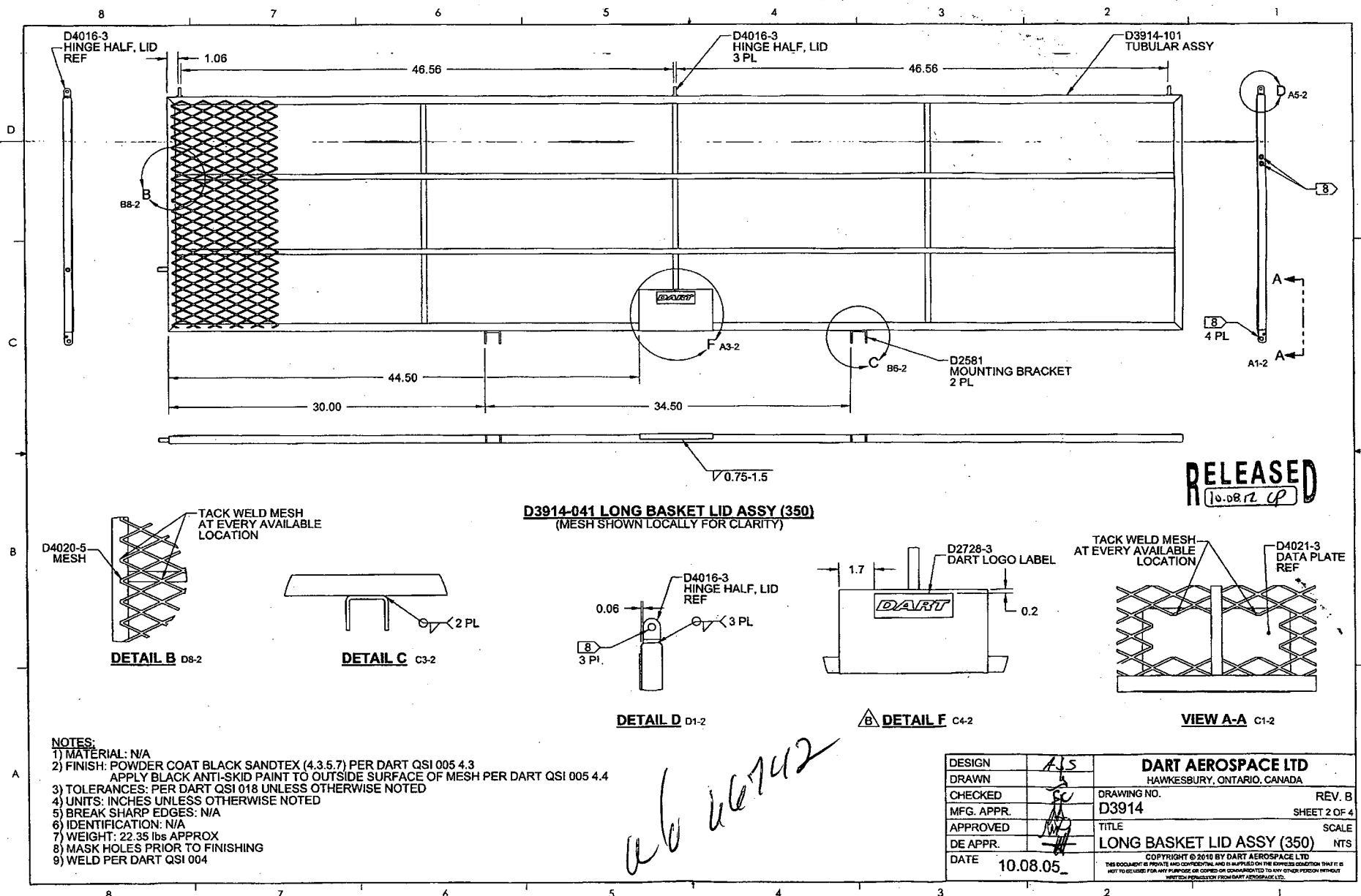
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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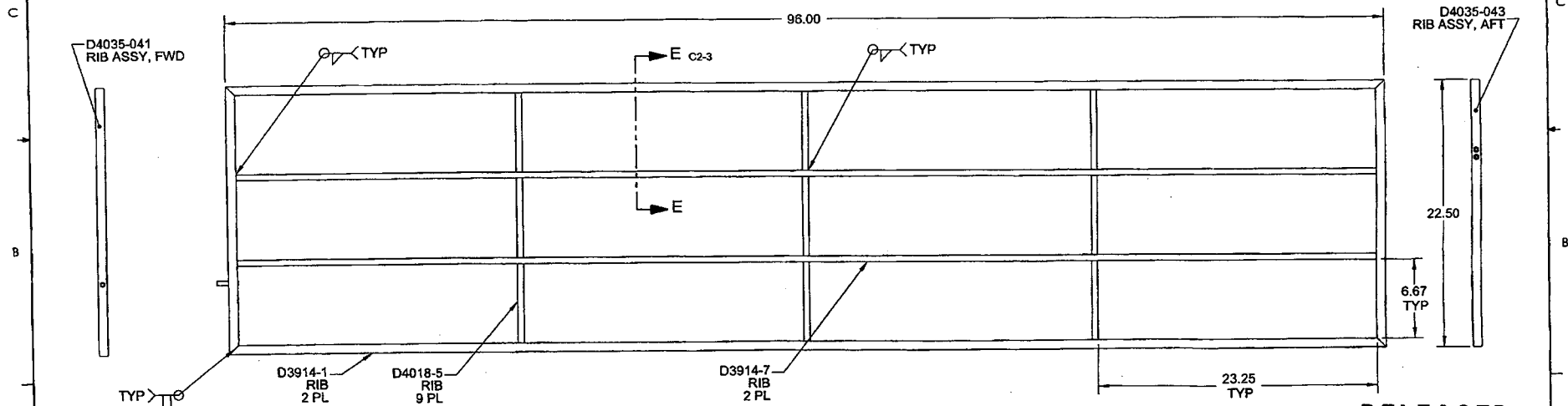
NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

ab 7/4/2



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-03-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	TC	DRAWING NO.	REV. B
CHECKED	TC	D3914	SHEET 3 OF 4
MFG. APPR.	MP	TITLE	SCALE
APPROVED	MP	LONG BASKET LID ASSY (350)	NTS
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

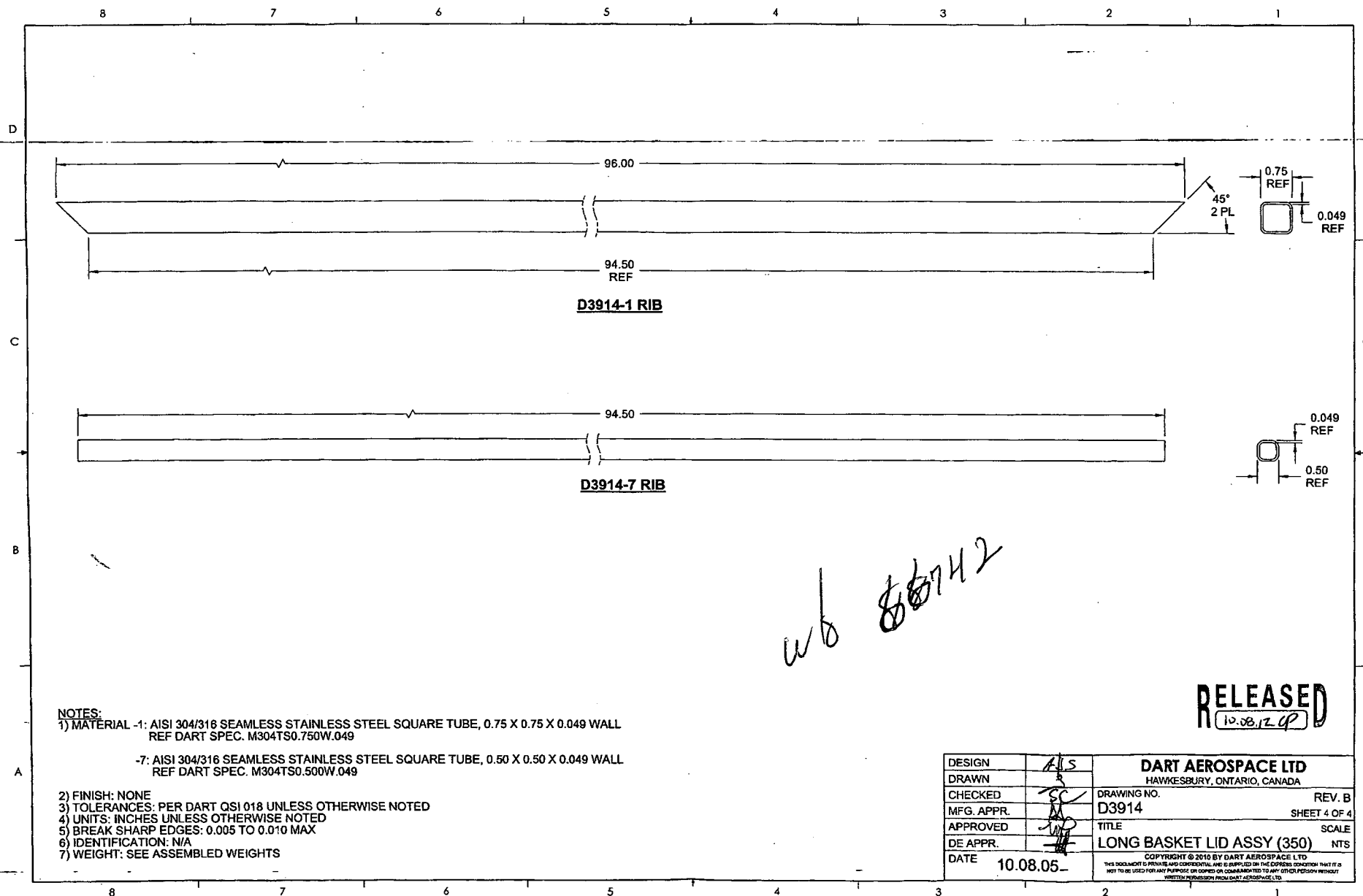
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC	SHEET 4 OF 4	
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	LONG BASKET LID ASSY (350)	
DE APPR.	SC	NTS	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries